

Work Order ID 73650

Friday, September 09, 2011 8:47:24 AM



Page 1

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 9/9/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK078	Rev A								

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

11/10/30

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/10/30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73650

Page 2

Friday, September 09, 2011 8:47:25 AM

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 9/9/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location: MAT 050

SL 11-11-03

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/11/13

MF

11-11-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 09, 2011 8:47:22 AM

Page 1

Work Order ID: 73650



Parent Item: DSK078



Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 9/9/2011

Required Date: 9/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6104-005

Manufactured

No

Each

14.0000

10



Round Billet, 17-4

SH 6/10/30

Location

Loc Qty

Loc Code

MAT

12

70254

12

MAT047

2

71179

2

9/1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order: 43650
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

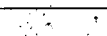
FIRST ARTICLE INSPECTION DIMENSION SHEET



☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.712	2.711	2.712	2.711	2.710
B	4.946	4.966		4.966	4.957	4.958	4.958	4.960
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.101	.101	.101	.101
F	2.934	2.954		2.945	2.946	2.945	2.946	2.946
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.925	.925	.925	.925	.925
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.109	0.129		.119	.120	.117	.118	.117
L								
M								
N								
O								
P								

Measured by:  **Date:** 11/10/30

Audited by:  **Date:** 11-11-03

Prototype Approval:  **Date:**

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM 	

DART AEROSPACE LTD		Work Order:	73650
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.711	2.712	2.712	2.711	2.712
B	4.946	4.966		4.958	4.958	4.958	4.958	4.958
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		-.728	-.728	-.728	-.728	-.728
E	0.090	0.110		-.101	-.101	-.101	-.101	-.101
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.900	3.901	3.901	3.900	3.901
I	0.914	0.934		-.725	-.725	-.725	-.725	-.725
J	0.022	0.042		-.031	-.031	-.031	-.031	-.031
K	0.109	0.129		-.115	-.117	-.116	-.117	-.117
L								
M								
N								
O								
P								

Measured by: SL Date: 11/10/30

Audited by: SL Date: 11-11-03

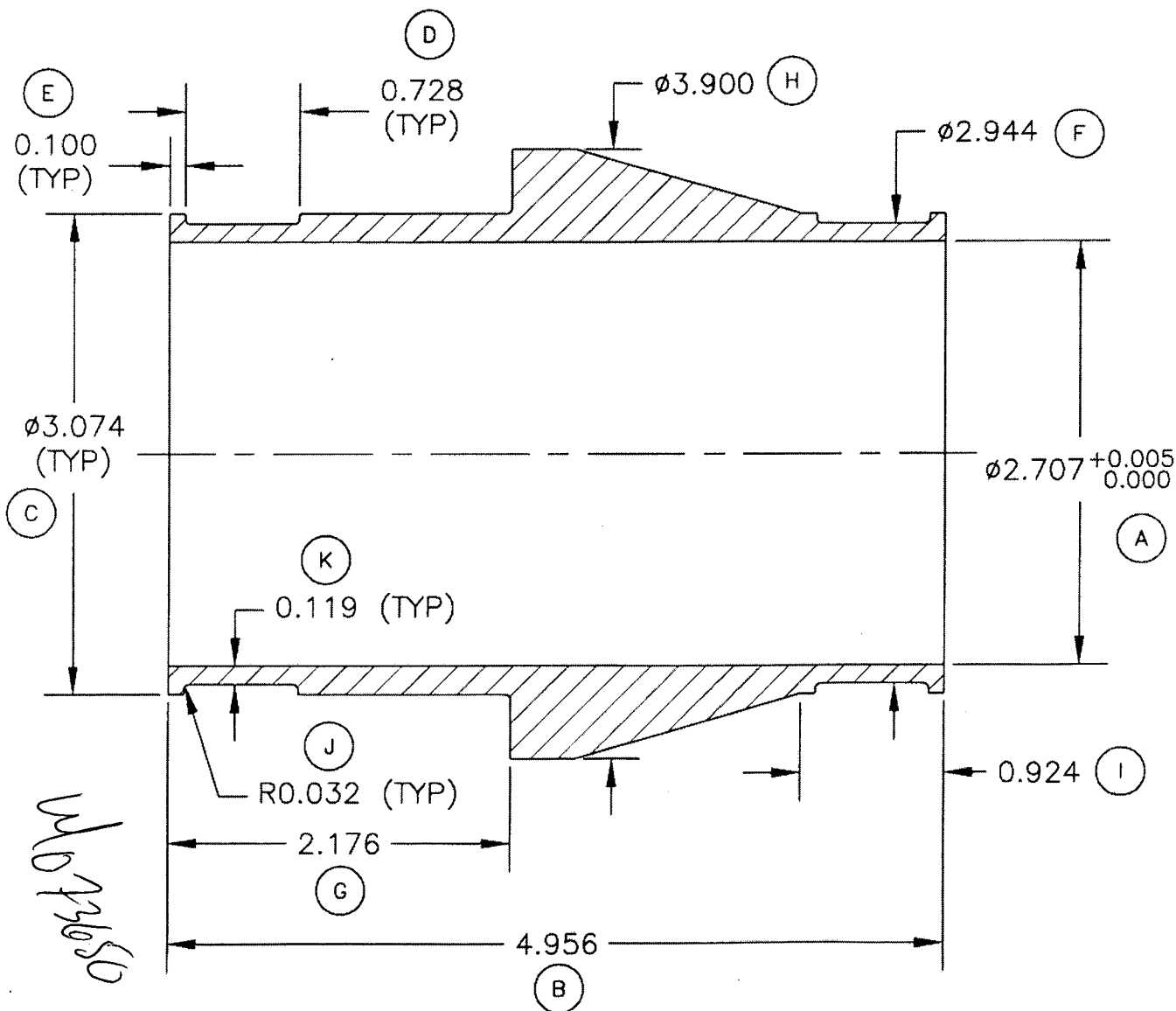
Prototype Approval: _____ Date: _____

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<u>SL</u>



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
#03.07.01



D2893-1 TURNING DETAIL

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries